

Date: Wednesday, 29/04/2009 3:01:55 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACKER PLATE
Job Number : 47602	
Estimate Number : 11802	
P.O. Number :	Part Number : D25281
This Issue : 29/04/2009 S.O. No. :	Drawing Number : D2528 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 43744	Material :
Written By :	Due Date : 30/04/2009 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 09.04.29</u>	
Comment : Est:C 00.06.26 Removed P/O for powder coat EC Est Rev:D 08-07-23 now made on water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0318 sf(s)/Unit Total : 0.3182 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

103755

Batch: 189-5-27

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2528

Dwg Rev: C1

Prog Rev: C1

189-5-27

15

Pro 7

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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189-5-27



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

509/15/27

412

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

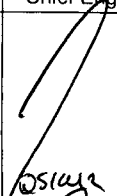
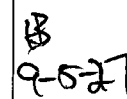
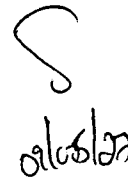
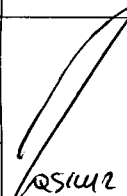
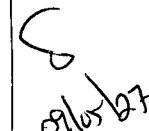
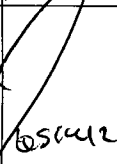
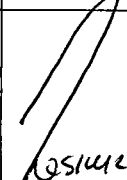

Acid etch and Alodine as per QSI 005 4.1

Feb 09/05/28

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2528-1 PAR #: D350-602-013/014 Fault Category: Prod / ~~Prod~~ Assl mal #small NCR: Yes No DQA: D Date: 09/05/07
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 09/05/07

NCR: <u>47602</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/5/07	# 20	During deburring it was found that Qty (15) parts are Delamating (material is pulling apart) around the hole causing a void in the mat. RC: Material Defect		Scrap AND Destroy AND Replace Qty (15) parts with 6061 T6 .063" mat.	 9-5-07	 09/05/07		 09/05/07
				As Per Draw. M# <u>110980</u>				 09/05/07

NOTE: Date & initial all entries

Date: Wednesday, 29/04/2009 3:01:55 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACKER PLATE

Job Number: 47602

Part Number: D25281

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

10:10

OVEN TEMPERATURE:

320°

FINISH TIME:

10:40

(X15)

UMP

09/05/28

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/05/28

(15)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST. 35

SS

09/05/28

(X15)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/29

(X15)

Job Completion



MF 09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>IP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
CI	05.04.27	1.46 WAS 1.460; 1.00 WAS 1.000	

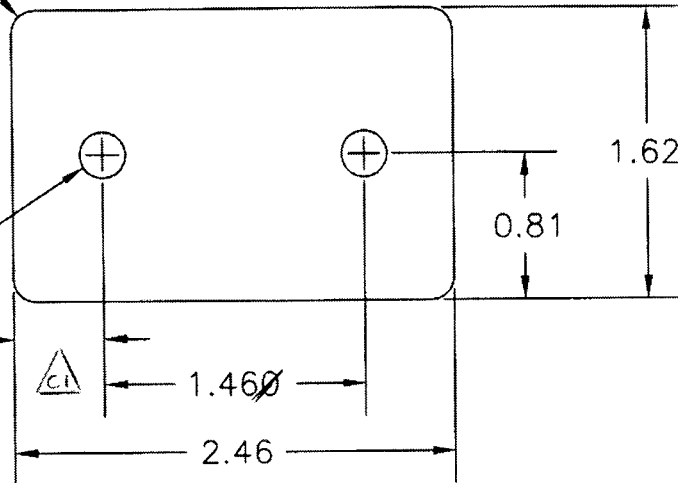
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW
[Signature]
01.12.03

Ø0.257 (TYP)

0.50



D2528-1

R0.13 (TYP)

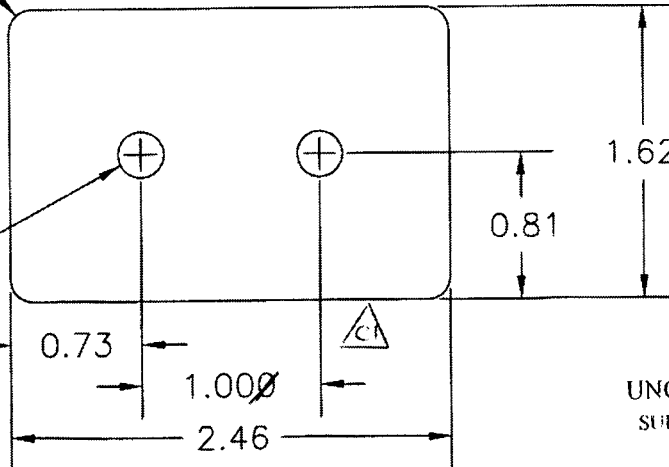
Ø0.257 (TYP)

→

0.73

1.00

2.46



D2528-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *47602*

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED